

Work Order ID 85532

85532

Page 1

June-11-12 9:46:43 AM

Item ID: D4030-041
Revision ID:
Item Name: Long Basket Assembly (350)

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 08/06/2012 Start Qty: 1.00 ***1***
Required Date: 22/06/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/11 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

1X SP
12-7-5
1 φ BR 12-7-5.

8/26/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85532

85532

Page 2

June-11-12 9:46:43 AM

Item ID: D4030-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
	<i>PPR85721</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/6

CK 12/7/6

W 12-7-06

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 85532

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

100 Each 34.0000 2 2

D2537

Bushing

**

SP

Location

Loc Qty

Loc Code

ST504

34

82896

34

D3913-041 Manufactured No

100 Each 0.0000 1 1

D3913-041

Long Basket Base Assembly, 350

**

2x

BL 12-7-5

D3914-041 Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

**

1

BL 12-7-5

D3917-3 Manufactured No

100 Each 47.0000 6 6

D3917-3

Washer

**

SP

Location

Loc Qty

Loc Code

FP

11

85028

11

ST070

36

84773

36

D3953-3 Manufactured No

100 Each 15.0000 2 2

D3953-3

Gas Spring Stud, Lid

**

6x

B 85488 1x SP

BL 7-5

Location

Loc Qty

Loc Code

ST075

15

82939

15

1x

W/O:		WORK ORDER CHANGES					
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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

100 Each

25.0000 2 2

D3953-7

Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

25

82940

25

D3953-9 Manufactured No

100 Each

37.0000 2

D3953-9

Gas Spring Washer

**

Location

Loc Qty

Loc Code

ST075

37

82941

37

D3953-17 Manufactured No

100 Each

19.0000 2

D3953-17

Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

19

82937

19

D3953-19 Manufactured No

100 Each

36.0000 1

D3953-19

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

36

82938

36

D3953-21 Manufactured No

100 Each

1.0000 1

D3953-21

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

1

81456

1

June-11-12 9:46:52 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100

Each

44.0000

1

1

D3969-3

Spring (Basket Lid)

**

SP

Location

Loc Qty

Loc Code

ST272

44

64285

1

81887

3

82942

40

AN3-14A

Purchased

No

100

Each

73.0000

4

4

AN3-14A

Bolt

**

MD2141 SP

Location

Loc Qty

Loc Code

ST352

73

121444

23

121708

50

AN3-16A

Purchased

No

100

Each

113.0000

2

2

AN3-16A

Bolt

**

SP 12-7-5

Location

Loc Qty

Loc Code

ST352

113

117441

47

118628

1

120986

15

121708

50

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Long Basket Assembly (350)

85532

D4030-041

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

68.0000

4

4

AN5-17A

Bolt

**

SP

Location

Loc Qty

Loc Code

338

4

121181

4

ST338

64

117872

34

121541

30

AN4-12

Purchased

No

100

Each

47.0000

3

3

AN4-12

Bolt

**

SP

Location

Loc Qty

Loc Code

ST357

47

118626

1

121652

46

AN310-4

Purchased

No

100

Each

128.0000

3

3

AN310-4

NUT

**

SP 12-7-5

Location

Loc Qty

Loc Code

ST344

128

120124

1

120518

1

121011

1

121349

25

121827

100

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Page 5

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

85532

D4030-041

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4 Purchased No

100 Each

32.0000 2 2

AN310C4

Nut

**

m 22/5/12 SP

Location

Loc Qty

Loc Code

ST344

32

120360

7

121166

3

121444

22

MS21042L3 Purchased No

100 Each

2,011.000 6 6

MS21042L3

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

2011

115835

4

117885

32

119017

884

119075

138

121349

143

121444

810

MS21042L5 Purchased No

100 Each

1,381.000 4 4

MS21042L5

Nut

**

SP 12-7-5

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

881

108827

4

116105

5

116548

43

117611

18

119109

795

17651

8

2937

8

June-11-12 9:46:52 AM

Shop Packet Print

Page 6

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 7

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85532

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

194.0000

3

3

MS24665-151

Cotter Pin

**

SP

Location

Loc Qty

Loc Code

ST309

194

17566

194

MS24665-300

Purchased

No

100

Each

149.0000

2

2

MS24665-300

Cotter Pin

**

3x

SP

Location

Loc Qty

Loc Code

GA

145

118234

145

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

738.0000

6

6

NAS1149F0432P

Washer

**

SP

Location

Loc Qty

Loc Code

ST275

738

121350

738

NAS1149F0563P

Purchased

No

100

Each

968.0000

4

4

NAS1149F0563P

Washer

**

6x

SP 12-7-5.

Location

Loc Qty

Loc Code

ST275

968

121350

968

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 85532

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

85532

D4030-041

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

596.0000

8

8

NAS1149F0332P

WASHER

**

SP

Location

Loc Qty

Loc Code

ST275

596

117735

13

119225

10

120986

200

121259

200

121584

9

121825

161

17317

3

8x

NAS1149C0432R

Purchased

No

100

Each

3.834.000

2

2

NAS1149C0432R

Washer

**

SP 12-7-5

Location

Loc Qty

Loc Code

ST297

1070

117291

70

119124

1000

ST298

2764

121255

2764

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

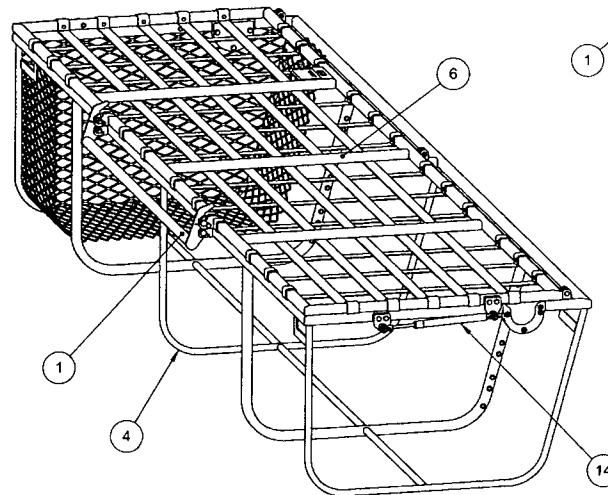
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

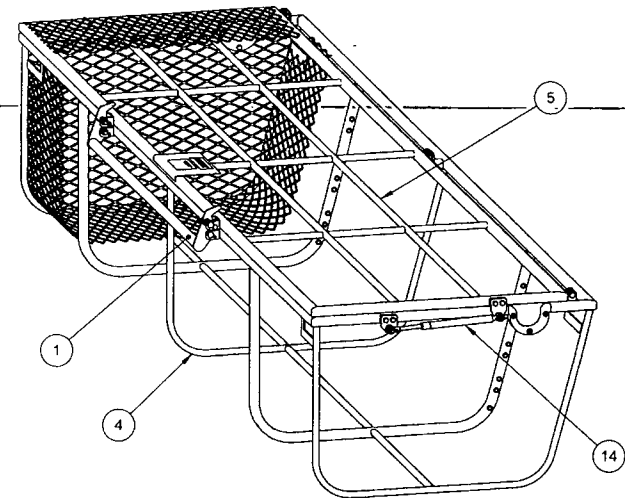
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85532 MLC
12/06/91

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
10-0812-6
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B-B-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	ANS-21A BOLT WAS ANS-18A: BOM & (D3-3)	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.16
REV	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JP		
MFG. APPR.	JFS		
APPROVED	W		
DE APPR.	#		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	SHEET 1 OF 3
DRAWING NO. D4030		TITLE LONG BASKET ASSY (350)	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

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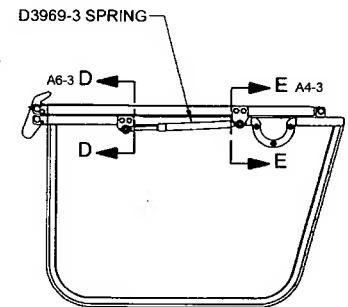
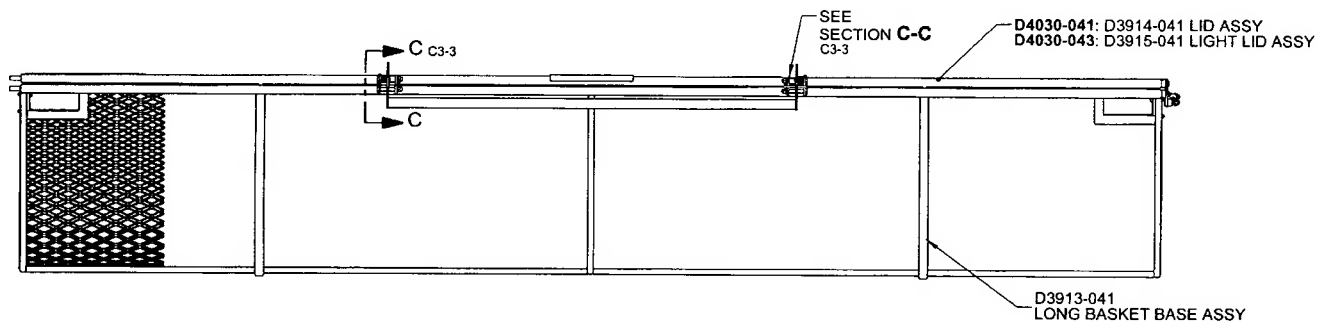
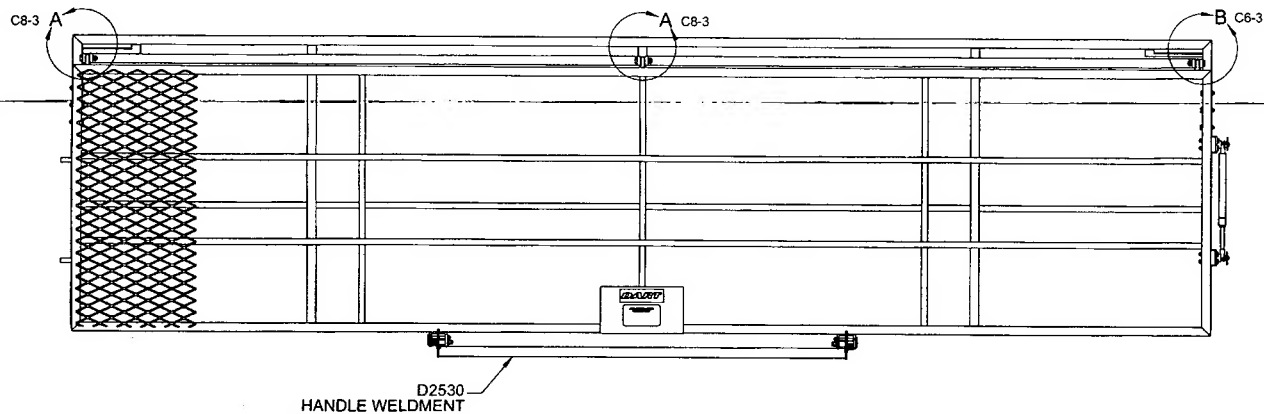
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

25532



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SEB	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS.
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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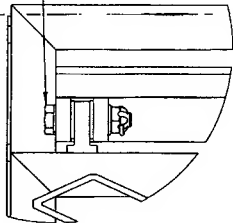
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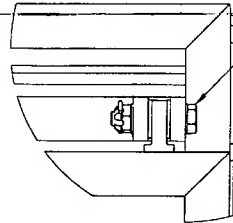
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



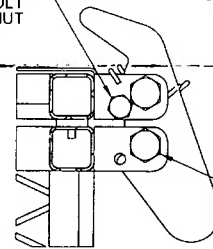
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

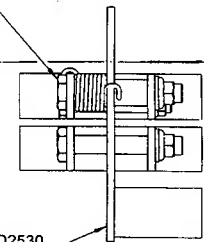


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries